

ATTACHMENT III - DETENTION AND DEPORTATION SPECIFICATIONS

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
EMBROIDERED EMBLEM

D1.1

- 0.1 It is the intention of the Immigration & Naturalization Service to establish the grade of embroidered emblems suitable for its needs. The grade, rendition and quality of embroidered emblems specified herein may not be deviated from in any way.
- 0.2 In the event of inconsistencies in the solicitation the specifications shall take precedence.
- 0.3 This section consists of the embroidery specification, plus various pages of ADDENDI.

1.0 DIMENSIONS

- 1.1 See attached photocopy for overall size, shape, color and layout. Emblems must measure at the widest part B* (see ADDENDUM) by the highest part C* (see ADDENDUM). For uniformity, all embroidery detail must be the same height, composition and weight as indicated on the design; stichle borders must be the same thickness all the way around and elements they enclose; design features must be the same height and thickness, design features must be clearly delineated; and all materials, elements and colors of the emblems must be of the same construction, size, thickness, depths, shades, and radiance as those of the established emblem design standard(s). Samples are available for review at the Immigration & Naturalization Service.

2.0 BACKGROUND MATERIAL

- 2.1 A. The background material must be D* (see ADDENDUM) of factory first quality manufacture. The material must be vat dyed 7 oz/yd., 65/35 polyester.cotton, and/or 100% emblem polyester, 2/1 or 3/1 construction, cured and preshrunk (resin impregnated and oven cured). Tensile strength must be in the 170/120 range, with an absolute minimum of 150/110.
- B. Seconds will not be acceptable. Embroiderer must indicate here, or on the back, the names of the background material and the manufacturer.
- C. There can be no exceptions to the material used as indicated in A. & B.

2.2 The color of the background material must be E* (SEE ADDENDUM).

3.0 FABRIC & THREAD

3.1 All materials must be tested for weight of material, tensile strength, material count and washability by the International Fabricare Institute, or similar industry testing agency, and must have been approved by them prior to use. Industry Standard test methods "AATCC" and "ASTM" must be followed for the physical testing of all base material. Test reports must be kept on file by the manufacturer, available for inspection, for one year after the materials are used.

4.0 EMBROIDERING

- 4.1 Prior to embroidering, a four mil polyurethane film sheet must be applied to the back side of the material. This is done to stabilize the material in the loom.
- 4.2 Emblems must be machine embroidered on swiss embroidery looms with automats and may not be produced on multihead equipment.
- 4.3 Thread color names and numbers are the applicable standard samples for shade and are obtainable from Robison-Anton (R/A# below), 175 Bergen Boulevard, Fairview, NJ 07022.
- 4.4 Thread colors and deniers, along with the necessary number of color changes for identified as follows and must be equal to F* Robison-Anton color shades.

COLOR R/A

DENIER

(SEE ADDENDUM)

- 4.5 The embroidery thread should be rayon yarn, finest quality, continuous filament regenerated cellulose type, in the deniers specified.
- 4.6 Each emblem must contain not less than P* (see ADDENDUM) stitches, Q* (see ADDENDUM) revolutions, not including the stitching in the overlocked merrow edge. Besides the customary and usual understanding of an embroidery "stitch" to mean that length of thread between two needle entry points on an embroidered emblem, one stitch is further identified as that space on a Schiffli embroidery program roll between two transport holes. One meter equalling one hundred stitches. Manufacturer must indicate here the number of stitches (and revolutions) in his/her versions of the bidden emblems.
- 4.7 Stitch scale must be of sufficient density as to preclude the "bleeding" (or see through) of the background material, and uneven matting (register) of color elements. There must be

sufficient underlay stitching to give a full three-dimensional, high-relief appearance to these emblems, and must have the exact appearance as the standard (see 0.2). No stitch may be greater than ten millimeters in length.

- 4.8 Double thread or any thread of different deniers or plys or composition will not be permitted in any part of these emblems. Single thread stitching in the deniers and plys above must be used throughout.

5.0 OVERLOCKED MERROW EDGE

- 5.1 Overlocked merrow edges must be applied to the emblems after the loom operation. Zig-zag stitches (in the configuration of alternating V's and inverted V's), supported by running stitches must be applied around the entire periphery of the individual emblems, under the overlocked merrow edge, to prevent the merrow edge from pulling away from the base material. Straight line running stitches alone will not serve this purpose; buttonhole stitched edge under the merrow edges do not meet this requirement.
- 5.2 The overlocked merrow edges consists of seven separate threads: five 150/2 denier rayon threads for the top (or front) portion of the edges or five 135/2 denier polyester and two 20/2 denier cotton threads for the underneath (or back side) of the edges.
- 5.3 The overlocked merrow edge density must be at least twenty threads per inch.
- 5.4 The overlocked merrow edges must be overrun a minimum of 3/8", and the seven end threads must be pulled through the entire length of the overrun to prevent ravelling. Threads must not be pasted down, taped, knotted, tied, fused into, or onto, or under the plastic film backing, cut off, tucked under, or chained off, but all seven threads must be pulled through the entire length of the overrun.
- 5.5 The color of the overlocked merrow edges must be R* (R/A S*) (see ADDENDUM).

6.0 FINISHING

- 6.1 A four mil polyurethane film sheet must be bonded to the back side of the emblems before die cutting. Sufficient heat must be applied to cause the film to melt and bond to the fabric and bobbin threads. The film must be capable of with standing home, commercial and industrial laundering formulas. The film must not stiffen nor crack in any of the previously mentioned wash formulas.

6.2 The film must be applied in such a manner as to preclude the crushing, flattening, or depressing of the three-dimensionality or high-relief of the embroidery, caused by the application of pressure during the bonding process; nor may there be jump stitch indentations on the fronts of the emblems. The film sheet must be applied to the span of loomed emblems, prior to die cutting, in the manufacturer's own facilities under constant supervision. This process or any other may not be subcontracted.

6.3 The film backing must completely engulf all the raised elements on the reverse (back) side of the emblems, and fill all depressions.

6.4 All emblems must be die cut with forged steel dies to the exact shape and geometry of the approved design.

7.0 WORKMANSHIP

7.1 No distortion of the exterior shape of the emblem is allowable. Emblems to be template checked.

7.2 All emblems must show a clear cut execution, and must be clean, neatly made, with full tension on all threads; they must be capable of laying completely flat on a smooth surface. Threads may not buckle nor show underlay stitching when emblems are bent.

7.3 There must be no broken stitches in the emblems; nor may and stitches be out of proper alignment. No parts of the emblems may be mended. Each quality control inspection is to have a copy of the embroidery specifications along with an approved sample.

7.4 All emblems must conform to the quality standards of these specifications in all characteristics. No exceptions.

8.0 SAMPLES

8.1 The successful vendor will be required to submit twelve (12) each actual loom production samples of the embroidered emblem(s) to the Immigration & Naturalization Service for its approval prior to shipment. These samples must incorporate all the details of the specifications provided.

9.0 INSPECTION AT THE MANUFACTURING FACILITY

9.1 Individual inspection of each and every embroidered emblem is required. Each emblem must be inspected against these specifications and a pass/fail determination must be made for each emblem. No random sampling inspection will be allowed. All emblems, which fail to pass this individual inspection,

must be retained by the manufacturer for a period of three months after the delivery of the entire order, and must be available for inspection by the purchaser. The manufacturer must maintain records of the number and percentage of rejected emblems and provide this information promptly upon request.

10.0 PACKAGING

10.1 Emblems must be packaged in clear plastic bags, 25/50 per package, depending on the size of the emblem. A packaging slip is inserted in each bag showing the manufacturer's name, the quantity and inspector's number.

11.0 TESTING

11.1 The Immigration & Naturalization Service reserves the right to have all delivered finished product tested by any independent testing agency. the test will be for compliance to this specification. Failure to pass test shall result in return of all delivered products for full credit, including any products which may have been used in the intervening time; the vendor will also be responsible to pay for cost of testing. If the testing is satisfactory, the Immigration & Naturalization Service will pay for the cost of testing.

12.0 LAUNDERING

12.1 Emblems must be able to withstand 52 home launderings, dry cleaning, commercial, industrial launderings and/or a combination of all. Emblems should not fade, shrink, distort, delaminate or in any way show signs of deterioration.

13.0 U.S. MADE

13.1 The emblems are to be produced entirely in the United States of America. All materials used in the production of these emblems, i.e. material, thread, plastic coating and bobbins are to be U.S. made.

ADDENDUM
EMBROIDERED EMBLEMS

DESCRIPTION: UNITED STATES IMMIGRATION & NATURALIZATION SERVICE
DETENTION AND DEPORTATION

1.1 DIMENSIONS: (B* & C)

3 5/8" x 3 1/2"

2.0 BACKGROUND MATERIAL: (D*)

65/35 Polyester/Cotton and/or 100% Emblem Polyester

2.2 BACKGROUND COLOR: (E*)

Midnight Navy Blue

4.4 EMBROIDERY COLORS: (F*)

<u>COLOR</u>	<u>CABLE COLOR</u>	<u>DENIER</u> <u>RAYON</u>
Flag Blue FD102	Midnight Blue HZ 67125	150/2
White FD008	White HA 67101	100/2
Special Dark Gold FDB73	Air Force Yellow HC 67102	100/2
J Metallic (Gold)	N/A	100/2
Royal FD3	Yale Blue 67176	100/2
Red FD17	Scarlet HL 67111	100/2
Kelly FD32	Prophet Green HCM 67187	150/2
Olive Green FD32	Olive Drab HAH 67133	100/2
J Metallic (Silver)	N/A	100/2
Black FD007	Black HAN 67138	100/2
Alpine Copper FD61	N/A	100/2
Coffee FD53	Brown HAL 67136	100/2

4.7 NUMBER OF STITCHES & REVOLUTIONS: (P* & Q*)

8,247 Stitches - 16,494 Revolutions

5.5 OVERLOOKED MERROW EDGE COLOR: (R* & S*)

<u>COLOR</u>	<u>CABLE COLOR</u>	<u>DENIER</u> <u>RAYON</u>
Flag Blue FD102	Midnight Blue HZ 67125	150/2



UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
STANDARD TIE TACK
D1.2

STYLE:

The tie tack shall be equal in appearance to, and the same size and design as, the 24 ligne regulation USINS uniform button, and shall utilize a gold-plated back fastener and button chain. The design shall incorporate a grommet washer to prevent rotation of the tie tack.

Made from 01-13662 Waterbury gilt regulation USINS uniform button, or equivalent.

**UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
NECKTIE
D2.1-A&B**

FABRIC: USBP-3a

COLOR: Black

STYLE: Style shall be a pre-tied four-in-hand on a metal bend-over type clip.

DESCRIPTION: The tie shall be lined and shall not exceed 3" at the widest end. It shall have French cuff ends and shall have a label loop for holding the narrow end of the tie. The narrow end of the tie shall incorporate a button down feature with three threadless buttonholes 5/8" and spaced 3/8" apart along the narrow end of the tie. The tie shall be pre-tied on to a large all metal bend-over style clip. The visible portion of the clasp is to be zinc bichromate with a black finish. The finished length of the tie from the top of the knot to the tip of the tie shall be available to accommodate officers 5 feet tall to 6 feet 6 inches tall. Extra long length is 2 1/2" longer than regular.

SIZES: A = Regular
B = Extra Long Length

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
ROUGH DUTY TROUSERS
D3.1

FABRIC: Approved fabric designated by number USBP-4, as stated.

STYLE: Long trousers, straight leg-with a modified boot cut, without cuffs and manufactured from up-to-date patterns and designed so that there will be no "peg" at the hip or "baggy" seat. The front of the rough duty trousers will be plain (no pleats), and the trousers shall have two hip pockets. Both hip pockets will be made to button.

- POCKETS:**
1. The front pockets shall have a minimum opening of 6" and shall measure at least 7" (F=5 1/2) deep from the bottom of the pocket opening to the bottom of the pocket. The top of the pocket opening shall begin approximately 1" in front of the side seam. The style of the front pockets is commonly referred to as quarter-top pockets. They shall be stitched turned and top stitched.
 2. The watch pocket will have an opening of approximately 2 1/2" and shall be located approximately 6" (F=4 1/2) on center from the front edge of the waistband. The watch pocket shall be approximately 3" deep and the opening of the watch pocket will be located along the bottom edge of the waistband.
 3. The hip pockets shall have an opening of approximately 5 1/2" and shall be approximately 6 1/2" deep. The hip pockets will be made utilizing the double-welt method and shall be finished without top stitching. The welts are to be interlined with Pellon. The hip pockets shall be folded at the bottom, top stitched at sides and bottom. All pockets shall be bartacked at the ends for reinforcement. Hip pocket buttons will be approximately 1/2" in diameter and of a matching dark green color. Buttonholes will be of the same specification as the dress jacket buttonholes.

POCKETING: All pocketing shall be fine quality polyester/cotton or polyester/rayon pocketing. The color of the pocketing shall be black and shall be made of a durable weight blend of at least 2.6 ounces per square yard and containing a durable press finish.

WAISTBAND: The waistband curtain shall be lined with the same fabric as the pocketing and the waistband shall close with a crush-proof hook and eye. The eye shall be stitched for added strength. The waistband must be attached to the trousers with a zig-zag stitch. The waistband must

utilize a three-strand rubberized strip (Snugtex) and shall contain a minimum of 1/2" Ban-rol type material to prevent waistband roll-over. The closed waistband outlet method of construction is to be used. The waistband shall measure approximately 2 1/2" on the inside and 2" on the garment side when finished.

FLY LINING:

The fly shall be constructed of the same materials as the waistband and pocketing. The right fly lining must be sewn to the left fly below the zipper with a strong closure and must be clean in appearance. There shall be a French fly closure on the inside of the right fly. The French fly must be constructed of the same fabric as the outer material of the trousers and shall button to close. The button and buttonhole shall match the hip pocket button and buttonhole specification.

FLY CLOSURE:

In addition to the French fly button closure, the fly shall close with a brass memory lock zipper bartacked at the bottom of the fly and going through the zippertape.

BELT LOOPS:

There shall be 7 belt loops, approximately 3/4" wide, fitted to the waistband, and long enough to accommodate a maximum belt width of 1 3/4". All loops shall be straight type loops. With the exception of the back center loop, all loops must be sewn into the bottom of the waistband at one end, and caught into the waistband curtain seam at the other end.

CREASES:

The front and back leg creases shall have Lintrak or equal crease treatment.

FINISHING:

The trousers must be seamed with matching thread and the seat seam must be stitched with a tandem needle machine. All exposed inside edges, must be surged. The trousers must be professionally pressed on hothead presses and must be properly shaped. The inseam and the outseam must be pressed open. All loose threads must be removed and properly trimmed. The rough duty trousers shall contain size and care labels and an official Detention/Deportation Officer uniform item designation label. This label shall be added prior to shipping to allow for inventory consolidation with like Border Patrol uniform items. All labels shall be sewn in and properly attached. Label location will be consistent. There shall be a 2" outlet, hem or additional length of material at the end of each trouser leg to accommodate length alterations and hemming adjustments and at the legs to accommodate alterations. There shall be a 2" outlet at the seat seam to accommodate alterations.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
LONG SLEEVE SHIRT (ROUGH DUTY)
D4.1

FABRIC: USBP-4a

STYLE: The style shall be a banded collar, long sleeve shirt with a full-length tail. Shirts will be cut on a form-fitting pattern, with a shaped body. The shirt is to have two pleated front outside breast pockets with scalloped flap style that button to close. The shirt shall have an inside sling-type badge holder and shoulder straps. The shirt back will have a scalloped yoke matching the front pocket flaps and shall incorporate a high count 100% polyester taffeta collar band and yoke trim.

COLLAR AND STAND: The banded style collar shall be two pieces and is to measure approximately 2 7/8" long at the points. The collar shall be made with permanent sewn-in or fused mylar collar stays that are sewn or fused to the collar lining. The collarstand height at the rear shall be approximately 1 1/2" and shall be top stitched 1/4" off the edge. The stand shall be made to fasten with one button.

FRONT: The shirt front shall be a 1 1/2 " placket front type style with an interlining. The left front shall have seven buttonholes equally spaced and properly finished. The right shirt front shall have seven buttons attached for proper closure and alignment.

SHOULDER STRAPS: There shall be a shoulder strap on each side of the shirt extending from the shoulder seam to within approximately 3/8" off the collar. They are to be top stitched 1/16" off of the edge and are to set on the yoke with the leading top stitch conforming to the front joining seam. The straps are to measure approximately 2" wide at the sleeve end, tapering to approximately 1 1/2" wide at the collar end. They are to be point shaped at the collar end and shall fasten with a single button set approximately 3/4" from the end point. The straps are to be x-stitched at the sleeve end for a length of approximately 2" (F=1 3/4") from the end of the strap.

BADGE

REINFORCEMENT: The badge reinforcement shall be a two-ply sling, 1" wide and centered over the left front pocket. The sling shall be stitched to the shoulder seam at the top and at the left pocket flap seam on the bottom. There shall be two circular stitched embroidered eyelets 1/14" apart placed so that the lower eyelet is approximately 3/4" above the left pocket flap.

POCKETS:

There shall be two breast pockets with plain pleats approximately 1 1/2" wide. The pockets are to measure 5 5/8" (F=4 1/2") wide and be approximately 6" (F=5") deep. The left breast pocket is to have a pencil slot on the right side approximately 1 1/2" (F=1 1/4") in width giving access to a pencil holder running the entire depth of the pocket on the inside. The pockets shall have mitered bottom corners measuring approximately 1" long and 3/8" wide positioned on both top outside edges of the pocket to correspond with the outer edges of the flap points. Each pocket is to have a Velcro tape 1" long and 3/8" wide positioned on both top outside edges of the pocket to correspond with the outer edges of the flap points. The tape is to be sewn down with bartacks and shall be the hook portion of a Velcro fastener. Each pocket shall have a button sewn approximately 1 1/2" (F=1 1/4") down from the top of the pocket on center to accommodate the corresponding flap buttonhole.

FLAP:

There shall be two scalloped flaps, top stitched around the edges, and measuring approximately 5 5/8" (F=4 3/4") wide, 2 3/4" (F=2 1/2") in deep at the center point, and 2 1/4" (F=2 1/4") deep at the side edges. The flaps are to be secured to the front of the shirt approximately 1/4" above the pocket with two rows of stitching 3/16" apart. The left flap is to have an "invisible" pencil opening on the right side of approximately 1 1/2" in width to correspond with the pencil slot of the pocket. The "invisible" pencil opening will provide a uniform appearance to both pocket flaps. This feature must be incorporated in the construction of the shirt. Both flaps are to be interlined with 100% polyester or cotton. The flaps shall button down to the pocket material.

The side points of the flaps are to be secured to the pockets by means of Velcro fasteners sewn to the outside edges of the flaps. The pile portion of a Velcro fastener, matching the dimensions of the corresponding hook portion, will be utilized for the flaps. The pile portion must be attached with bartacks during the manufacturing process before the flap is assembled to prevent the stitching from showing on the front of the flap.

**SLEEVES AND
CUFFS:**

The long sleeves will be cut straight and whole, with a 4 1/2" (F=4") sleeve vent. The sleeve shall have a one-piece banjo elbow reinforcement and vent facing. Banjo elbow reinforcement corners must be rounded and shall extend into the sleeve closing seam at the bottom. The reinforcement shall measure approximately 11" long and shall be approximately 2" wide at the cuff. The sleeve cuffs shall be 3" (F=2 5/8") wide and shall have rounded corners. There shall be two buttons with corresponding buttonholes on each cuff, with one button and buttonhole in the sleeve facing, approximately 3" from the top of the cuff. Both cuffs are to be interlined with 100% polyester or stabilized cotton.

BUTTONS:

All buttons will be first grade low luster melamine buttons approximately 1/2" in diameter and of a color closely matching the color of the shirt fabric.

STITCHING:

Single needle stitching will be used. All top stitching will be 1/16" off of the edge. The sleeve inserting and side close will be safety stitched.

THREAD

All sewing threads are to be color fast 100% Polyester core cotton wrapped, polyester core, polyester wrapped or five spun polyester to match the color of the shirt fabric.

LINING:

All collars, flaps, and placket fronts are to be interlined with 100% polyester or cotton (550 weight) stabilized interlining.

YOKE:

There shall be a center pointed western style yoke on the back matching the scalloped design of the front pocket flaps. The depth of the yoke is to be approximately 4" at the center point and 3 1/8" at the sides.

NAMEPLATE

REINFORCEMENT: There shall be two circular stitched embroidered eyelets, 1 5/8" apart and centered horizontally over the right breast pocket, 1/2" above the top of the pocket.

EMBLEM

ATTACHMENT: The official Detention and Deportation Officer emblem will be attached 1/2" below the left shoulder seam, centered on the sleeve, and sewn with poly-core thread matching the color of the emblem. It is to be attached during the assembly of the shirt.

FINISHING:

The shirt must be constructed with matching thread and must be properly pressed. All loose threads must be removed and properly trimmed. The shirt shall contain size and care labels and an official Detention/Deportation Officer uniform item designation label. This label, along with the D&D shoulder patch, shall be added prior to shipping to allow for inventory consolidation with like Border Patrol uniform items. All labels shall be sewn in and properly attached. Label location will be consistent.

CREASES:

There shall be five military creases three in back and two in front. The front creases are to go underneath the pocket and flaps. The creases are to have Lintrak crease treatment.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
SHORT SLEEVE SHIRT ROUGH DUTY
D4.2

FABRIC: USBP-4a

STYLE: The style shall be a banded collar, short sleeve shirt with a full-length tail. Shirts will be cut on a form-fitting pattern, with a shaped body. The shirt is to have two pleated front outside breast pockets with scalloped flaps that button to close. The shirt shall have an inside sling-type badge holder and shoulder straps. The shirt back will have a scalloped yoke matching the front pocket flap style and shall incorporate a high count 100% polyester taffeta collar band and yoke trim.

SHORT SLEEVES: The sleeves are to be straight and whole, and they shall have a 7/8" hem. The sleeves shall finish approximately 9 1/2" (F=7 1/4") from the shoulder seam.

COLLAR AND STAND: The banded style collar shall be two pieces and is to measure approximately 2 7/8" long at the points. The collar shall be made with permanent sewn-in mylar or fused collar stays that are sewn or fused to the 100% cotton collar lining. The collarstand height at the rear shall be approximately 1 1/2" and shall be top stitched 1/4" off the edge. The stand shall be made to fasten with one button.

FRONT: The shirt front shall be a 1 1/2" placket-front type style with an interlining. The left front shall have seven buttonholes equally spaced and properly finished. The right shirt front shall have seven buttons attached for proper closure and alignment.

SHOULDER STRAPS: There shall be a shoulder strap on each side of the shirt extending from the shoulder seam to within approximately 3/8" of the collar. They are to be top stitched 1/16" off of the edge and are to be set on the yoke with the leading top stitch conforming to the front joining seam. The straps are to measure approximately 2" wide at the sleeve end, tapering to approximately 1 1/2" wide at the collar end. They are to be point shaped at the collar end and shall fasten with a single button set approximately 3/4" from the end point. The straps are to be x-stitched at the sleeve end for a length of approximately 2" (F=1 3/4") from the end of the strap.

BADGE

REINFORCEMENT: The badge reinforcement shall be a two-ply sling, 1" wide and centered over the left front pocket. The sling shall be stitched to the shoulder seam at the top and at the left pocket flap seam on the bottom. There shall be two circular stitched embroidered eyelets 1 1/4" apart placed so that the lower eyelet is approximately 3/4" above the left pocket flap.

POCKETS:

There shall be two breast pockets with plain pleats approximately 1 1/2" wide. The pockets are to measure 5 5/8" (F=4 1/2") wide and be approximately 6" (F=5") deep. The left breast pocket is to have a pencil slot on the right side approximately 1 1/2" (F=1 1/4") in width giving access to a pencil holder running the entire depth of the pocket on the inside. The pockets shall have mitered bottom corners measuring approximately 1" long and 3/8" wide positioned on both top outside edges of the pocket to correspond with the outer edges of the flap points. Each pocket is to have a Velcro tape 1" long and 3/8" wide positioned on both top outside edges of the pocket to correspond with the outer edges of the flap points. The tape is to be sewn down with bartacks and shall be the hook portion of a Velcro fastener. Each pocket shall have a button sewn approximately 1 1/2" (F=1 1/4") down from the top of the pocket on center to accommodate the corresponding flap buttonhole.

FLAP:

There shall be two scalloped flaps, top stitched around the edges, and measuring approximately 5 5/8" (F=4 3/4") wide, 2 3/4" (F=2 1/2") deep at the center point, and 2 1/4" deep at the side edges. The flaps are to be secured to the front of the shirt approximately 1/4" above the pocket with two rows of stitching 3/16" apart. The left flap is to have an "invisible" pencil opening on the right side of approximately 1 1/2" in width to correspond with the pencil slot of the pocket. The "invisible" pencil opening will provide a uniform appearance to both pocket flaps. This feature must be incorporated in the construction of the shirt. Both flaps are to be interlined with 100% polyester or cotton. The flaps shall button down to the pocket material. The side points of the flaps are to be secured to the pockets by means of Velcro fasteners sewn to the outside edges of the flaps. The pile portion of a Velcro fastener, matching the dimensions of the corresponding hook portion, will be utilized for the flaps. The pile portion must be attached with bartacks during the manufacturing process before the flap is assembled to prevent the stitching from showing on the front of the flap.

BUTTONS: All buttons will be first grade low luster melamine buttons approximately 1/2" in diameter and of a color closely matching the color of the shirt fabric.

STITCHING: Single needle stitching will be used. All top stitching will be 1/16" off of the edge. The sleeve inserting and side close will be safety stitched.

THREAD: All sewing threads are to be color fast 100% polyester core cotton wrap, polyester core, polyester wrapped or five spun polyester.

LINING: All collars, flaps, and placket fronts are to be interlined with 100% polyester of cotton (550 weight) stabilized interlining.

YOKE: There shall be a center pointed western style yoke on the back matching the scalloped design of the front pocket flaps. The depth of the yoke is to be approximately 4" at the center point and 3 1/8" at the sides.

NAME PLATE

REINFORCEMENT: There shall be two circular stitched embroidered eyelets, 1 5/8" apart and centered horizontally over the right breast pocket, 1/2" above the top of the pocket.

EMBLEM

ATTACHMENT: The official Detention and Deportation emblem will be attached 1/2" below the left shoulder seam, centered on the sleeve, and sewn with poly-core thread matching the color of the emblem. It is to be attached during the assembly of the shirt.

FINISHING: The shirt must be constructed with matching thread and must be properly pressed. All loose threads must be removed and properly trimmed. The shirt shall contain size and care labels and an official Detention/Deportation Officer uniform item designation label. This label, along with the D&D shoulder patch, shall be added prior to shipping to allow for inventory consolidation with like Border Patrol uniform items. All labels shall be sewn in and properly attached. Label location will be consistent.

CREASES: There shall be five military creases, three in back and two in front. The front creases are to go underneath the pocket and flaps. The creases are to have Lintrak crease treatment.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
BASEBALL CAP - SUMMER
D5.1-A

- STYLE:** Open mesh baseball style with five-piece crown contour shape and direct embroidery.
- MATERIALS:** The top visor and front crown section shall be made from **Graniteville Chetopa 2026** material and shall be laminated to 1/8" open cell foam with tricot nylon lining. The back four section of the crown shall be made from 100% nylon mesh to match twill material. The visor interliner shall be a sheet stock of non-absorbing material such as sheet rubber. The tape for the crown seams and sweatband material shall be made from a high quality bias rayon. Finished product to be **black**.
- FRONT PANEL:** To be high crown style, the front panel shall be constructed of one piece which shall be equal to 1/3 of the circumference of the cap. The panel shall be 7 1/4" wide, 4" high at the center measured from the top of the visor and 7 1/4" high at each side. The front panel shall be laminated.
- VISOR:** The visor and visor lining shall be twill fabric interlined with a visor stiffener and sewn into eight parallel rows of 3/16" gauge stitching that follow the contour of the visor. The visor shall finish smooth without twists or puckers. The visor shall be 2 1/2" long and 7 3/4" wide.
- SWEATBAND:** The sweatband shall finish a minimum of 1 3/8" wide and be interlined with foam sheeting. The sweatband shall not pucker, curve, arc, buckle or twist.
- CROWN:** The crown pieces shall be sewn together, the seam allowance pressed flat, then sewn down with 5/8" tape with stitch type 301 or 401. The crown shall be laminated. A heavy plastic mesh government stay, tricot bound, is secured to that it touches the top of the front panel.
- CLOSING SEAMS:** The visor and sweatband shall be sewn to the crown with type 301 stitch and the sweatband shall finish smooth and be flat against inside of cap. A button covered with basic material, size 22 line, shall be set into the crown at the junction of the five crown pieces.
- REAR OUTLET:** The rear outlet shall be folded under and taped down. The size adjuster shall be plastic tape to match twill material with seven holes and pins that snap together to provide a secure closure.

DIRECT EMBROIDERY: A "U.S. IMMIGRATION OFFICER DETENTION & DEPORTATION" patch shall be directly embroidered onto the front panel in the center. The patch shall be the shape, color and size in accordance with the figure on page 26.

The wording and patch on the front panel shall be machine embroidered on embroidery machines with automats, and shall not be produced on multi-head equipment.

The solid-stitched background field shall be a running stitch field. A blatt (or loose) stitched field will not be acceptable. There shall be no visible "corduroy" effect. A "corduroy" type field is one in which the overall appearance consists of a regular succession of stitches and spaces, similar to the regular rises and falls in corduroy fabric, and is not acceptable.

Thread color names and numbers are the applicable standard sample for shade and are contained in the DOD Standard Color Card of Official Standardized Shades for Heraldic Yarns for Embroidery and Ribbons. The Color Card is obtainable from the Color Association of the United States, Inc., 343 Lexington Avenue, NY, NY 10016 (Tel No. 212-683-9531).

Thread colors and deniers, along with the necessary number of color changes are identified as follows, and shall closely match the following Heraldic Yarn color shades:

<u>DESCRIPTION</u>	<u>CABLE NAME</u>	<u>CABLE NO.</u>	<u>RAYON DENIER</u>
White	White HA	76101	100/2
Special Dark Gold	Air Force Yellow HC	67103	100/2
National Blue	Yale Blue HLA	67176	100/2
J Gold Metallic	*-----	-----	----
Red	Scarlet HL	67111	100/2
Dark Green	Prophet Green HLM	67187	100/2
Olive Green	Olive HAJ	67134	100/2
J Silver Metallic	*-----	-----	----
Midnight Navy	Midnight Blue HZ	67125	100/2
Black	Black HAN	67138	100/2
Orange 224	*-----	-----	----
Dark Brown	Brown HAL	67136	100/2

* For these colors, refer to: Robison-Anton Textile
175 Bergen Boulevard
Fairview, NJ 07022

Thread shall be rayon yarn, finest quality, continuous filament, and colorfast, in the deniers specified above.

Besides the customary and usual understanding of an embroidery "stitch" to mean that length of thread between two needle entry points on an embroidered emblem, one stitch is further identified as that space on a shiffli embroidery program roll between two transport holes. One meter equalling one hundred stitches.

Stitch scale shall be of sufficient density as to preclude the "bleeding" (or see through) of the background material, and uneven matting (register) of color elements. There shall be sufficient under-lay stitching to give a full three-dimensional, high-relief appearance to the embroidery. No stitch may be greater than ten millimeters in length.

Double thread of any thread of different deniers of plys will not be permitted in any part of the embroidery. Single thread stitching in the deniers and plys above shall be used throughout.

THREAD:

The thread shall be polyester, size 40 or cotton-wove cotton-covered polyester, size 50 color dyed to match basic material except the direct embroidery threads which shall conform to the specifications above.

STITCHES PER INCH:

The stitches per inch shall be 7-9 for all cap operations except 5 stitches per inch on the visor.

SIZING:

A sizing fiber shall be attached to the sweatband before the sweatband is installed so that the finished cap will retain its size and shape.

SIZES:

The caps will be sized as required:
S/M; L/XL; XXL

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
BASEBALL CAP - WINTER
D5.1-B

- STYLE:** Baseball style cap with five-piece crown contour shape and direct embroidery.
- MATERIALS:** The top visor and five-crown sections shall be made from **Graniteville Chetopa 2026** material and shall be laminated to 1/8" open cell foam with tricot nylon lining. The visor interliner shall be a sheet stock of non-absorbing material such as sheet rubber. The tape for the crown seams and sweatband material shall be made from a high quality bias rayon. Finished product to be **black**.
- FRONT PANEL:** To be high crown style, the front panel shall be constructed of one piece which shall be equal to 1/3 of the circumference of the cap. The panel shall be 7 1/4" wide, 4" high at the center measured from the top of the visor and 7 1/4" high at each side. The front panel shall be laminated.
- VISOR:** The visor and visor lining shall be twill fabric interlined with a visor stiffener and sewn with eight parallel rows of 3/16" gauge stitching that follow the contour of the visor. The visor shall finish smooth without twists or puckers. The visor shall be 2 1/2" long and 7 3/4" wide.
- SWEATBAND:** The sweatband shall finish a minimum of 1 3/8" wide and be interlined with foam sheeting. The sweatband shall not pucker, curve, arc, buckle or twist.
- CROWN:** The crown pieces shall be sewn together, the seam allowance pressed flat, then sewn down 5/8" tape with stitch type 301 or 401. The crown shall be laminated. A heavy plastic mesh government stay, tricot bound, is secured so that it touches the top of the front panel.
- CLOSING SEAMS:** The visor and sweatband shall be sewn to the crown with type 301 stitch and the sweatband shall finish smooth and be flat against inside of cap. A button covered with plastic material, size 22 line, shall be set into the crown at the junction of the five crown pieces.
- REAR OUTLET:** The rear outlet shall be folded under and taped down. The size adjuster shall be plastic tape to match twill material with seven holes and pins that snap together to provide a secure closure.

DIRECT EMBROIDERY: A "U.S. IMMIGRATION DETENTION & DEPORTATION" patch shall be directly embroidered onto the front panel in the center. The patch shall be the shape, color and size in accordance with the figure on page 26.

The wording and patch on the front panel shall be machine embroidered on embroidery machines with automats, and shall not be produced on multi-head equipment.

The solid-stitched background field shall be a running stitch field. A blatt (or loose) stitched field will not be acceptable. There shall be no visible "corduroy" effect. A "corduroy" type field in one in which the overall appearance consists of a regular succession of stitches and spaces, similar to the regular rises and falls in corduroy fabric, and is not acceptable.

Thread color names and numbers are the applicable standard sample for shade and are contained in the DOD Standard Color Card of Official Standardized Shades for Heraldic Yarns for Embroidery and Ribbon Ribbons. This Color Card is obtainable from the Color Association of the United States, Inc. 343 Lexington Avenue, NY, NY (Tel No. 212-683-9531).

Thread colors and deniers, along with the necessary number of color changes are identified as follows, and shall closely match the following Heraldic yarn color shades:

<u>DESCRIPTION</u>	<u>CABLE NAME</u>	<u>CABLE NO.</u>	<u>RAYON DENIER</u>
White	White HA	76101	100/2
Special Dark Gold	Air Force Yellow HC	67103	100/2
National Blue	Yale Blue HLA	67176	100/2
J Gold Metallic	*-----	-----	----
Red	Scarlet HL	67111	100/2
Dark Green	Prophet Green HLM	67187	100/2
Olive Green	Olive HAJ	67134	100/2
J Silver Metallic	*-----	-----	----
Midnight Navy	Midnight Blue HZ	67125	100/2
Black	Black HAN	67138	100/2
Orange 224	*-----	-----	----
Dark Brown	Brown HAL	67136	100/2

* for these colors, refer to: Robison-Anton Textile Company
175 Bergen Boulevard
Fairview, NJ 07022

Thread shall be rayon yarn, finest quality, continuous filament, and colorfast, in the deniers specified above.

Besides the customary and usual understanding of an embroidery "stitch" to mean that length of thread between two needle entry points on an embroidered emblem, one stitch is further identified as that space on a shiffli embroidery program roll between two transport holes. One meter equalling one hundred stitches.

Stitch scale shall be of sufficient density as to preclude the "bleeding" (or see through) of the background material, and uneven matting (register) of color elements. There shall be sufficient underlay stitching to give a full three-dimensional high-relief appearance to the embroidery. No stitch may be greater than ten millimeters in length. Double thread of any thread of different deniers of plys will not be permitted in any part of the embroidery. Single thread stitching in the deniers and plys above shall be used throughout.

THREAD:

The thread shall be polyester, size 40 or cotton-wove cotton covered polyester, size 50 color dyed to match basic material except the direct embroidery threads which shall conform to the specifications above.

STITCHES PER INCH:

The stitches per inch shall be 7-9 for all cap operations except 5 stitches per inch on the visor.

SIZING:

A sizing fiber shall be attached to the sweatband before the sweatband is installed so that the finished ca; will retain its size and shape.

SIZES:

Caps will be sized as required:
S/M; L/XL; XXL



UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
WINTER ROUGH DUTY HAT
D5.2-A

- FABRIC:** 100% Felt - 3 x Beaver or better with color designates as Belgian Belly. The inside crown shall be level with white taffeta and have a clear plastic inside top overliner.
- STYLE:** The style shall be a western style soft brim hat with indentations on each side of the crown crease.
- CROWN:** The crown shall be of medium height (5" to 5 1/2") and shall be steam creased from front to rear to a depth of approximately 1 1/4". There shall be two indentations, one on each side of the crown crease and measuring between 5" to 6" in width and between 1" to 1 1/2" in depth. The crown shall not contain any ventilation holes or grommets.
- CROWN BAND:** The crown band shall be three cord crown ribbon with a plain square knot bow on the left side. The width of the crown band shall be approximately 3/8". The finish is to be raw edge and the color shall match the crown and brim.
- BRIM:** The brim shall be soft and flexible and shall measure between 2 5/8" and 2 3/4" in width. The color of the brim shall be identical to the crown.
- SWEATBAND:** The sweatband shall be genuine leather, dyed brown and self-forming. It shall be interlined with a moisture barrier. The sweatband shall be approximately 1 5/8" wide.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
SUMMER ROUGH DUTY HAT
D5.2-B

- FABRIC:** 100% Ventilated Milan-braided Straw with color designated as Belgian Belly.
- STYLE:** The style shall be a western style stiff brim hat with a slight curl and indentations on each side of the crown crease.
- CROWN:** The crown shall be of medium height (5" to 5 1/2") and shall have a crease from front to rear to a depth of approximately 1 1/4". There shall be two indentations, one on each side of the crown crease and measuring between 5" to 6" in width and between 1" to 1 1/2" in depth.
- CROWN BAND:** The crown band shall be three cord crown ribbon with a plain square knot bow on the left side. The width of the crown band shall be approximately 3/8". The finish is to be raw edge and the color shall match the crown and brim.
- BRIM:** The brim shall be stiff and shall have a slight curl at the side edges. The width of the brim shall be approximately 3". The color of the brim shall be identical to the crown.
- SWEATBAND:** The sweatband shall be genuine leather dyed brown and self-forming. It shall be interlined with a moisture barrier. The sweatband shall be approximately 1 5/8" wide.

**UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
AIRCRAFT PILOTS OVERSEAS CAP
D5.3-A&B**

FABRIC:

**USBP-2-A
USBP-3-B**

STYLE:

Identical in design to the official officer's overseas cap of the U.S. Marine Corps. Conforms to styling design in military specification MIL-C-43419D(GL), 26 September 1984.

Exceptions to design are:

1. Colors as specified in fabric specification
2. No cord braid
3. Sweatband to be dyed brown
4. Grommet color must match fabric color

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
ROUGH DUTY JACKET
D6.1

GENERAL DESIGN

The jacket shall be waist length, with elastic waistband, and zipper front with double flap closure. There will be five (5) snap closures in the front, slash pockets with snap closure, detachable snap off hood with drawstring, band collar with knit inner collar measuring (F=15 by 2) and two piece raglan sleeves with and hook and loop closures, permanent taffeta lines and zip-out Thinsulate liner using CS 200 in the body and CS 100 in the sleeves, channel stitched 6 inches apart to nylon taffeta (see permanent liner fabric). The removable liner shall have a left pocket of shell material, measuring 8 1/2 x 5 3/4 inches wide, and a right pocket constructed in the same manner measuring 8 by 6 (F=7 x 5 1/4) inches. Both pockets shall be backtacked at the upper corners. The left and right permanent liner pocket shall be a hanging type, measuring 9 by 4 7/8" (F=7 3/4 x 4 7/8") with the bag made of shell fabric. Both pockets to be made out of the shell goods material with hook and loop closures. All drawstrings shall be elastic drawcord with mini buck toggles at both ends for closure. The coat shall have a hanger braid in the neck.

DETACHABLE THINSULATE LINING

Liner is a full body and sleeve liner made from materials above with attached wristlets. Thinsulate insulation shall be quilt stitched in 6 inch wide channel stitches. The liner shall be removable by means of a 46 (F=44) inch aluminum zipper. The liner shall be fully cut, coming to within 2 inches (+ or - 1/2") of the bottom hem. There shall be patch pockets on the liner fronts measuring 8 1/2 x 5 3/4 (F=7 x 5 1/4) inches wide. The corners shall be backtacked on the top corners. The sleeves of the quilted liner shall be held in position by two buttons secured to the permanent liner, one to the top sleeve and another to the under sleeve. Body to be CS-200 Thinsulate, sleeves to be CS-100 Thinsulate. Edges of the liner shall be nylon bound. A curtain for the liner must be sewn around the inside for attachment of the liner. Curtain edges must be nylon bound.

PERMANENT LINING

The permanent body lining shall be cut full for ease. There shall be a two piece sleeve, front and back pieces. The lining shall be sewn into the fronts, neck and hem seams. Each front shall have an inside double welt hanging pocket measuring 9 inches high x 4-7/8 inches wide (F=7 3/4 x 4 7/8). The pocket bags shall be cut from the shell fabric.

SLEEVES

Two piece, raglan style, with gusset at sleeve bottom. Adjustment tab 2" at seam tapering to 1 3/4, 2-1/2" long. Hook side velcro adjustment on tab 1" x 1". Velcro pile strip 1" wide x 3" long starting approximately 1/2" from underseam. This allows for cuff adjustment.

INTERLINING

The following parts shall be interlined: Collar, and Fronts.

POCKETS

The pockets shall be a slash pocket with 1 1/4" by 5 7/8" welt. The pocket will have a snap closure on the welt and pocket bag. The pocketing shall be shell goods.

HOOD

The detachable drawstring hood shall be constructed of 2 crown pieces. The hood shall be lined with the shell material with Thinsulate CS-100 sandwiched in between. There will be four snaps to attach the hood to the collar. The hood extensions shall be closed by two snaps. The drawcord shall be black elastic drawcord with black plastic mini bucks on each end for tightening. The cord shall be in 3/4" channel exiting through a black metal eyelet approximately 3" from hood edge.

COLLAR AND COLLAR STAND

The permanent collar and stand shall be made of two plies of the basic fabric plus the interlining. The interlining shall be sewn to the under collar. The collar snaps shall be for attachment of the hood to the jacket. The snaps shall be spaced 4" to 4 1/2" apart. The collar shall be 3 1/2" wide and be sewn into each jacket fly front edge.

SNAPS

Shall be non rusting, 24 ligne, nickel on brass, heavy duty closure, with a black chemical coated cap.

KNIT WRISTLETS AND COLLAR

Shall be 100% polyester, 1 x 1 rib knit, measuring 3" long. The inner collar shall be 100% polyester, 2 x 2 rib knit, measuring 15 x 2 inches.

STITCHING AND THREAD

All stitching shall be even and uniform as per the standard sample. Thread shall be size # 50 rayon wrapped polyester, polyester or spun polyester core, vat dyed.

BADGE TAB

Eyelets to be sewn eyelet holes 1 1/4" apart, center to center. Top eyelet 6 1/2" down from the arm/shoulder join and 7" from jacket edge.

NAME TAB

Eyelets to be sewn eyelet holes 1 1/2" apart, center to center on right front approximately 5 1/2" from front edge and approximately 8" down from the point of collar and sleeve joining.

REQUIREMENTS FOR THE BASIC (SHELL) FABRIC

Cloth type: U.S. Border Patrol Fabric USBP-4, dyed black.

REQUIREMENTS FOR THE PERMANENT BODY (TAFFETA) LINING

Cloth Type: 100 nylon taffeta bright, semi-bright or semi-dull,
plain weave
Denier: warp: 70 fill: 70
Fibers: Nylon # 66 continuous filament yarns with 34 filaments
Melting Point: 450 degrees Fahrenheit
Weight: 2 oz. per square yard
Warp: 160 (+ or - 2)
Fill: 90 (+ or - 2)
Tearing Strength (lbs)-Warp: minimum of 3.5 Fill: minimum of 2.1
Breaking Strength (lbs)-Warp: minimum of 125 Fill: minimum of 85
Maximum Shrinkage Warp: less than 3% Fill: less than 2%
Color Fastness and Cracking: Good

REQUIREMENTS FOR THE THINSULATE LINER

Nylon Face and Backing Fabric

See requirements for permanent body lining fabric, same except 104 x 68 pick.

Thinsulate insulation

Type: CS 200 Thinsulate by 3M (body liner)
Type: CS 100 Thinsulate by 3M (sleeve liner)

Emblem: Detention and Deportation emblem attached approximately 8 inches down from collar seam on left sleeve.

Stitching: There shall be 1/4" gauge two needle stitching on the following:

Sleeve ends
Slash Pocket facings
Armholes
Top of Sleeves
Hood, Crown

Labels: The jacket shall contain size and care labels and an official Detention/Deportation Officer uniform item designation label. All labels shall be sewn in and properly attached. Label location to be consistent.

Sizes: x Small - 3x Large

Slide Fasteners: Front - Black Debrin #5 with 2-way slider.

Measurements**Male****Female**

Back	=	26"	21 1/2"
Sleeve from collar	=	31"	26"
Chest from bottom of armhole	=	56"	44"
Hood crown (base of hood over crown to end of visor)	=	22"	20"

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
THERMAL VEST
D6.2

REQUIREMENTS FOR THE BASIC (SHELL) FABRIC

Cloth type: U.S. Border Patrol Fabric USBP-4, dyed black.

REQUIREMENTS FOR THE PERMANENT BODY LINING

Cloth type: 100% nylon taffeta bright, semi-bright, or semi-dull,
 plain weave
Denier: Warp: 70 fill: 70
Fibers: Nylon #66 continuous filament yarns with 34 filaments
Melting points: 450 degrees Fahrenheit
Weight: 2 oz. per square yard
Warp: 160 (+/-2)
Fill: 90 (+/-2)
Tearing Strength (lbs.)--Warp: Minimum of 3.5, Fill: Minimum of 2.1
Breaking Strength (lbs.)--Warp: Minimum of 125, Fill: Minimum of 85
Maximum Shrinkage--Warp: Less than 2%, Fill: Less than 2%
Color Fastness and Crocking: Good

REQUIREMENTS FOR THE THINSULATE LINER

Nylon Face and Outside Pocket Linings

See Requirements for permanent body lining fabric.

Thinsulate Insulation

Type: CS 150 Thinsulate by 3M, Quilted 6" channel to body lining fabric

Pocketing

The pocket lining shall be lining fabric.

Slide Fasteners

The front zipper shall be black deiran, size #5, 17 1/2" in length.

General Design

The vest shall be waist length insulated vest featuring zip front, knit collar, lower patch pockets, and two inside pockets. The vest shall be joined and closed along the periphery and then edge stitched 1/16 inch from the edge.

Collar

The collar shall be rib knit 2 x 2, 100% polyester. The collar shall be 1 3/4 inches wide. There shall be a piece of hangar braid set into the neck seam.

Badge Tab and Name Plate Holder

The badge tab shall be embroidered eyelets sewn into the left breast. The eyelets shall be spaced 1 3/8 inch apart center to center. The bottom eyelet shall be approximately 3 1/2 inches down from the collar start and 4 1/2 inches over from the front. The name plate holder shall be located 3 1/4 inches down from collar start and 4 inches over from right front edge. They shall be 1 5/8 inch on center.

Pockets

There shall be 2 patch pockets on the front of the jacket. The lower patch pockets shall be 7 1/2 inches in width, 9 inches in depth, and will be lined with the lining material. The pocket opening shall measure 6 3/4 inches. Pocket opening corners shall be bartacked. The inside pockets shall be sewn to a piece of the basic shell material which is then sewn to the lining. Inside pockets shall be constructed from the basic shell cloth. The inside left pocket shall measure 4 1/2 by 9 inches, the inside right pocket shall measure 5 by 6 1/2 inches.

Labels:

The vest shall contain size and care labels and an official Detention/Deportation uniform item designation label. All labels shall be sewn in and properly attached. Label location shall be consistent.

Sizes

The size range shall be EXTRA SMALL TO DOUBLE EXTRA LARGE - UNISEX.

TABLE OF MEASUREMENTS IN INCHES

Size:	XS	S	M	L	XL	XXL
Chest:	40	44	48	52	56	60

(measured at armhole and side seam, +/- 3/4 inch)

Back length, size medium = 23 1/2
increases 1/2 inch for each size (example: size Large Regular = 26
inches, measured from neck seam to bottom of waistband, +/- 1/2 inch)

**UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
COMMANDO SWEATER
D6.3**

REQUIREMENTS FOR THE YARN

Type: 100% pure new virgin wool (worsted, spun, long fiber)
Content: not less than 95% based on dry weight of sweater
Quality: 56/58 microns (diameter)
Count: worsted 2 ply/11 1/4, times 2 ends
Colorfastness: Good
Dry cleaning: Good
Crocking: Good
Color: Dyed to match Fabric designated Immigration Inspectors = black.

REQUIREMENTS FOR THE RE-ENFORCEMENT PATCH FABRIC

Fabric designated USBP-1, as stated, dyed black.

REQUIREMENTS FOR THE TAPE RE-ENFORCEMENT

Type: Cotton woven tape, 5/8 inches wide conforming to Type II of DDD-T-86
Color: Approximately same as sweater.

REQUIREMENTS FOR THE THREAD

Type: Cotton, conforming to Type IA3, ticket no. 40 and 50 of V-T-276.
Colorfastness: Good

REQUIREMENTS FOR THE INTERLINING (epaulets)

Cloth Type: 50% polyester, 50% nylon fusible cloth conforming to class 3 of Mil-C-29365
Weight: 1.7 oz. to 2.2 oz. per square yard
Breaking Strength [lbs]-- machine direction, 3 lbs. per inch, across machine 2, lbs. per inch
Maximum Shrinkage-- Warp: less than 1% Fill: less than 1%
Color: oxford grey

GENERAL DESIGN:

Shall be pullover style, wool, 2 x 2 rib throughout, v-neck, with a straight body and set in sleeves. The number of counted ribs from side seam to side seam across the chest and bottom welt shall be equal to the chest size in inches. Extra long body length with knitted welt and turnback cuff design for adjusting sleeve length. Durable cloth patches shall re-enforce shoulders and elbows. The body and sleeve welts shall be knit with a non-ravelling edge. Badge and name tab shall sewn on the inside so as not to show and epaulets shall be attached with a button.

KNITTING:

The garment is to be knitted from 2 x 2 construction throughout, using .54 inches of yarn per stitch, except the bottom welt which is to be .46 inches of yarn per stitch, commencing with a knitted welt. The body 6 inches below the armpit when stretched by hand is to extend with out damage to a total width of at least 38 inches.

TAPE

SEAM CONSTRUCTION:

All sweater seams shall be stitched using an overlock machine, except for the shoulder and sleeve cuffseams which shall also be over sewn with a seam cover using a wool cover thread for neat appearance and comfort. All seams shall be straight and neat with thread ends trimmed.

TAPE REINFORCEMENT:

The shoulders and underarms shall be reinforced with 5/8 inch cotton tape, to prevent underarm seam from coming apart under stress. The tape shall measure approximately 4 inches in length under the arm and the entire length of the shoulder seam, and shall match (approximately) the color of the sweater.

PATCHES:

The sweater is to have re-enforcing patches on each shoulder and sleeve. When the sweater is laid flat, the bottom of each shoulder patch shall meet when a straight line is drawn from patch to patch, ensuring a uniform appearance. The patches shall match the color of the sweater. The patches, with raw edges turned in, are to be secured by a double needle lock stitch, except for the edge incorporated into the sleeve seam. There shall be no puckering, gathering or distortion, where the patches are sewn to the sweater. No glue may be used to fold patches before stitching. The shoulder patch shall measure approximately 9 inches by 5 inches (size med). The sleeve patch shall be contoured to fit the arm, measuring approximately 10 inches by 4 inches (size large).

BADGE PATCH:

There shall be a badge tab on the inside left breast measuring approximately 1 inch by 3 3/4 inches, attached to the sweater using a lock stitch. The eyelets shall be spaced 1 1/4 inches apart. Eyelets are to be sewn (not metal).

NAME PLATE

HOLDER:

There shall be a name plate holder on the inside right breast measuring approximately 1 inch by 4 inches, attached to the sweater using a lock stitch. The eyelets shall be spaced 1 5/8 inches apart. Eyelets are to be sewn (not metal).

EPAULETS:

The epaulets shall have three points; shall be smooth and flat, and uniform in construction and placement. They shall be made from two plies of re-enforcement fabric and one ply of fusible interlining (for added shape retention). The plies shall be x-stitched, turned inside out and top stitched. Each epaulet shall be set to the shoulder, turned back on itself. It shall finish 2 inches wide at the shoulder seam, tapering to 1 7/8 inches wide at the pointed end. The epaulets shall be attached to the shoulder patch at the neck using a button. The epaulets shall be x-stitched at the shoulder and have a double needle to stitch on the sides and point.

BUTTONS:

Color shall match the basic wool fabric.

EMBLEMS:

Specified Detention and Deportation emblem shall be sewn to the left sleeves 1 inch below the shoulder seam. Thread shall be poly core to match the emblem.

FINISHING:

The sweater and patches shall be pressed for a second time before shipping, insuring a neat, un-wrinkled appearance when issued. All patches and epaulets shall be stitched with two rows of stitching 1/4 inch apart. All loose threads shall be trimmed properly. The sweater must contain care labels and an official uniform item designation label.

MEASUREMENTS:

The length of a size large sweater from shoulder seam at the armhole to the bottom welt shall be approximately 27 inches (+ or - 3/4 inch). The width shall be measured by counting the number of ribs from side seam to side seam--the number of ribs equaling the chest size of the sweater in inches. The width of the V-neck opening shall be 5 inches (+ or - 1/2 inch).

SIZES:

Size availability will be XS (32-34), S (36-38), M (40-42), L (44-46), XL (48-50), XXL (52-54), XXXL (56-58) to fit men and women.

UNIFORM RAINGEAR

The uniform raingear for Detention consists of a police-style raincoat and protective plastic covers for both rough duty and dress hats. It is important that the color of the material utilized in the raincoat is consistent and dyed to match the standard shade specified by USBP Fabric #2. The raincoat must come with a protective pouch suitable for compact storage.

Additional types of raingear are in the field-testing stage and items such as leggings and a short jacket may be added to the program after the first year. Material specifications would be consistent with the raingear material specifications.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
RAINCOAT
D7.1

STYLE AND

CONSTRUCTION:

The raincoat shall be a waterproofed, fully cut, well balanced raglan shoulder design, with two slash cut through pockets, corduroy collar, collar stand, taffeta quarter and sleeve lining, and a nylon mesh yoke lining in the back for ventilation. The outer jacket shall be constructed with no shoulder seam, but with a set-in sleeve. The collar is to be finished with points approximately 2 5/8 inches long, measuring 2 3/4 (F=2 1/4) inches in width at center back. There shall be 6 snap fasteners, spaced 6 1/2 (F=5 1/4) inches apart. The bottom snap shall be approximately 12 (F=15) inches from the bottom of the coat. The facing shall be fully interlined, approximately 5 1/2 (F=4 1/2") tapering to 4 inches wide at bottom. The slash pockets shall be diagonally placed, the welts measuring approximately 11 (F=10 1/2") inches long. Pocket depth shall be approximately 10 1/2 (F=9) inches. The pocket opening shall be 10 (F=9 3/4) inches to permit easy access to trouser pockets or revolver.

EMBLEMS:

The Detention Enforcement Officer emblem shall be attached to the left shoulder 1 inch below the shoulder seam.

I.D. LABEL

An owner identification label shall be sewn on the back lining just below the shoulder seam.

TABLE OF MEASUREMENTS IN INCHES

<u>Size:</u>	<u>34</u>	<u>36</u>	<u>38</u>	<u>40</u>	<u>42</u>	<u>44</u>	<u>46</u>	<u>48</u>	<u>50</u>	<u>52</u>	<u>54</u>
Chest:	44	46	48	50	52	54	56	58	60	62	64
{measured at armhole and side seam + or - 3/4 inch}											
Sweep:	56	58	60	62	64	66	68	70	72	74	76
{measured at hem + or - inch}											
Back length size 40: Shorts =47 Reg. =49 Longs=51 X Longs=53											
{measured from collar stand to bottom of hem + or - 3/4 inch}											
Hem Width Bottom: 1 inch {+ or - 1/4 inch}											
Hem Width Sleeve: 3/4 inch {+ or - 1/4 inch}											
Sleeve Inseam Size 44: Shorts=17 1/2 Reg.=18 1/2 Longs= 19 1/2											
Long=20 1/2 {+ or - 1/2 inch}											

REQUIREMENTS FOR THE COATED FABRIC

Cloth Type: Nylon, plain weave, type 66, treated with fluorocarbon water & stain release agents.

Denier: Warp 200 Fill 200

Warp ends per inch: 62 (+ or - 2)

Filling ends per inch: 50 (+ or - 2)
 Weight uncoated: 2.5 - 3.0 oz per square yd.
 Coating Weight: 2.0 oz. (+ or - 0.25 oz) pr (1.1 or 1.3 oz.) ** see below
 Coating type: Polyurethane (pigmented to match fabric color) shall resist oil, discoloration and be free of odor.

	MINIMUM	MAXIMUM	FEDERAL TEST METHOD
Overall weight {oz/s sq yard}	4.5	5.0	5041
Breaking Strength (lbs) Warp: 200			5100
Warp and Filling Filling: 150			
Tearing Strength (lbs) Warp: 7.5 (+ or - .5)			5134
Warp and Filling Filling: dd 5.5. (+ or - .5)			
Abrasion Resistance 1000 cycles {H-18 500 Grams}			5306
Hydrostatic Resistance 100 PSI {Original}			5512
Hydrostatic Resistance 90 PSI {After 3 Washes}			5512
2 inch Adhesion (lbs) 22			5970

REQUIREMENTS FOR INTERLINING

Type: 100% cotton osnaburg
 Color: Natural or white
 Weight: 2.34 yds/lb
 Count: warp 36, fill 32
 Break Strength: warp 68 lbs, fill 50 lbs
 Max. Shrinkage: warp 1.5%, fill 1.0%

REQUIREMENTS FOR NYLON TAFFETA QUARTER LINING

Cloth Type: 100% nylon taffeta bright, semi-bright or semi-dull, plain weave
 Color: BP Green to match Fabric #1
 Denier: warp: 70 fill: 70
 Fibers: Nylon #66 continuous filament yarns with 34 filaments
 Melting Point: 450 degrees Fahrenheit
 Weight: 1.8 oz. per square yard
 Warp: 104 [+ or - 2]
 Fill: 86 [+ or - 2]
 Tearing Strength [lbs]--Warp: minimum of 3.5 Fill: minimum of 2.1
 Breaking Strength [lbs]--Warp: minimum of 125 Fill: minimum of 85
 Maximum Shrinkage--Warp: less than 2%
 Color Fastness and Crocking: Good

REQUIREMENTS FOR THE CORDUROY COLLAR

Cloth Type: Stacord 14 wale
 Color: Olive Drab Green

REQUIREMENTS
FOR MESH:

The mesh shall be a military cloth conforming to the requirements of MIL-C-3395 and its amendments.

REQUIREMENTS
FOR THREAD:

Single needle sewing shall use polyester core, cotton or rayon wrapped, size #50. Double needle sewing shall use 100% spun polyester thread, size #70 in the needles, size #100 in the loopers.

SEAMS:

Sleeve seams, sleeve setting seams and body joining seams shall be 3/16" gauge, double needle chain stitch, lap seam felled construction. Seams shall be free from puckering, pleats, runoffs and raw edges.

SEAM WATER-
PROOFING:

Seam tape shall be transparent, compatible with the coating compound and assume all the characteristics of the coating compound after application. The tape shall be applied by ultrasonic or hot air methods. The tape shall not be affected by weather, temperature or storage. The taped seams shall be tested for waterproofing in accordance with Federal Test #191, Method #5514. There shall be no appearance of water in the test area when the hydrostatic head is raised to 50 centimeters for a period of 3 minutes.

SNAPS:

Shall be non rusting, 24 ligne, nickel on brass, heavy duty closure.

EYELETS:

Three eyelets, vertically spaced 1 inch apart, shall be placed under each sleeve. The eyelets shall be black aluminum, size #100.

MISCELLANEOUS:

The raincoat shall contain size and are labels and on official Detention Enforcement Officer uniform item designation label. All labels shall be sewn on and properly attached. Label locations will be consistent. Color shall match USBP fabric standard, as stated.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
HAT COVER
D7.2

DESCRIPTION: Plastic raincovers for Detention rough-duty and dress hats, as specified. Covers shall have elastic shirred, in a band around the bottom of the cover and shall be made available with a carrying pouch for storage. One size fits all. Dyed to match green color standard.

**UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATIONS**

**FABRIC
DO.1.1**

USBP-1

DESCRIPTION: Fabric #1

WEAVE: Serge

WEIGHT: 16 - 16 1/2 ounces per linear yard in 60 inches

FIBER CONTENT: 100 percent wool

PLY OF YARN: 2 ply warp and filling

BREAKING STRENGTH: 115 pounds in the warp
90 pounds in the filling

CONSTRUCTION: 68 ends per inch
58 picks per inch

FABRIC MUST BE MARKED ON THE BACK FACE WITH MILL TRADEMARK OR KAUMOGRAPH.

RAEFORD #8250-92727 OR EQUIVALENT

COLOR SHALL NOT VARY FROM DESIGNATED 92727 SHADE

USBP-1-CV BLUE-RAEFORD #8250-8818 OR EQUIVALENT

COLOR SHALL NOT VARY FROM DESIGNATED 8818 SHADE

**UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION**

**FABRIC
DO.1.1A**

USBP-1A

DESCRIPTION: Fabric #1A

WEAVE: Tropical

WEIGHT: 10 - 10 1/2 ounces per linear yard in 60 inches

FIBER CONTENT: 100 percent wool

PLY OF YARN: 2 ply warp and filling

BREAKING STRENGTH: 55 pounds in the warp
50 pounds in the filling

CONSTRUCTION: 50 ends per inch
46 picks per inch

FABRIC MUST BE MARKED ON THE BACK FACE WITH MILL TRADEMARK OR KAUMOGRAPH.

RAEFORD #8321-92727 OR EQUIVALENT

COLOR SHALL NOT VARY FROM DESIGNATED 92727 SHADE

**UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION**

**FABRIC
D0.1.2**

USBP-2

DESCRIPTION: Fabric #2

WEAVE: Elastique

WEIGHT: 17 - 17 1/2 ounces per linear yard on 60 inches

FIBER CONTENT: 55 percent dacron polyester, 45 percent wool

PLY OF YARN: 2 ply warp and filling

BREAKING STRENGTH: 220 pounds in the warp
130 pounds in the filling

CONSTRUCTION: 122 ends per inch
85 picks per inch

FABRIC MUST BE MARKED ON THE BACK FACE WITH MILL TRADEMARK OR KAUMOGRAPH.

RAEFORD #645-92727 OR EQUIVALENT

COLOR SHALL NOT VARY FROM DESIGNATED 92727 SHADE

USBP-2-CV BLUE-RAEFORD #646-96 OR EQUIVALENT

COLOR SHALL NOT VARY FROM DESIGNATED 96 SHADE

**UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATIONS**

**FABRIC
D0.1.2A**

USBP-2A

DESCRIPTION: Fabric #2A

WEAVE: Gabardine

WEIGHT: 11 - 11 1/2 ounces per linear yard in 60 inches

FIBER CONTENT: 55 percent dacron poliesther, 45 percent wool

PLY OF YARN: 2 ply warp and filling

BREAKING STRENGTH: 150 pounds in the warp
80 pounds in the filling

CONSTRUCTION: 112 ends per inch
55 picks per inch

FABRIC MUST BE MARKED ON THE BACK FACE WITH MILL TRADEMARK OR KAUMOGRAPH.

RAEFORD #521-92727 OR EQUIVALENT

COLOR SHALL NOT VARY FROM DESIGNATED 92727 SHADE

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION
FABRIC
D0.1.3

USBP-3

DESCRIPTION: Fabric #3

WEAVE: Serge

WEIGHT: 11 1/2 - 12 ounces per linear yard in 60 inches

FIBER CONTENT: 75 percent dacron polyester, 25 percent wool

PLY OF YARN: 2 ply warp and filling

BREAKING STRENGTH: 90 pounds in the warp
175 pounds in the filling

CONSTRUCTION: 79 ends per inch
57 picks per inch

FABRIC MUST BE MARKED ON THE BACK FACE WITH MILL TRADEMARK OR KAUMOGRAPH.

RAEFORD #3918-92727 OR EQUIVALENT

COLOR SHALL NOT VARY FROM DESIGNATED 92727 SHADE

USBP-3-CV BLUE-RAEFORD #3918-610 OR EQUIVALENT

COLOR SHALL NOT VARY FROM DESIGNATED 610 SHADE

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION

FABRIC
DO.1.3A

USBP-3A

DESCRIPTION: Fabric #3A

WEAVE: Tropical

WEIGHT: 9 - 9 1/2 ounces per linear yard in 60 inches

FIBER CONTENT: 75 percent dacron polyester, 25 percent wool

PLY OF YARN: Singles

BREAKING STRENGTH: 75 pounds in the warp
150 pounds in the filling

CONSTRUCTION: 50 ends per inch
46 picks per inch

PILLING: 4.9 rating out of 5.0

FABRIC MUST BE MARKED ON THE BACK FACE WITH MILL TRADEMARK OR
KAUMOGRAPH.

RAEFORD #3906-92727 OR EQUIVALENT

COLOR SHALL NOT VARY FROM DESIGNATED 92727 SHADE

**UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION**

**FABRIC
D0.1.4**

USBP-4

DESCRIPTION: Fabric #4

WEAVE: 2 up - 1 down right-hand twill

WEIGHT: 7.5 ounces per square yard

FIBER CONTENT: 65 percent polyester, 35 percent cotton

YARN SIZE: Warp 14/1
Fill 14/1

BREAKING STRENGTH:

TENSILE: 175 pounds in the warp
118 pounds in the fill

TEAR: 5.5 pounds in the warp
5.5 pounds in the fill

CONSTRUCTION: 81 ends per inch
53 picks per inch

FABRIC MUST BE MARKED ON THE BACK FACE WITH MILL TRADEMARK OR TRUTH MARK.

GRAINTEVILLE 2026-49530 OR EQUIVALENT.

COLOR SHALL NOT VARY FROM DESIGNATED 49530 SHADE

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION

FABRIC
D0.1.4A

USBP-4A

DESCRIPTION: Fabric #4A
WEAVE: Tropical
WEIGHT: 4.5 ounces per square yard minimum
FIBER CONTENT: 65 percent polyester, 35 percent cotton

YARN SIZE: Warp 25/1
Fill 25/1

BREAKING STRENGTH:

TENSILE: 130 pounds in the warp
60 pounds in the filling

TEAR: 6.6 pounds in the warp
3.8 pounds in the filling

CONSTRUCTION: 101 ends per inch
52 picks per inch

FABRIC MUST BE MARKED ON THE BACK FACE WITH MILL TRADEMARK OR TRUTH MARK.

GRANITEVILLE NEW DEMNITY 49530 OR EQUIVALENT

● COLOR SHALL NOT VARY FROM DESIGNATED 49530 SHADE

THIS FABRIC SUBJECT TO CHANGE